

Work Order ID 55465

January 19, 2010 9:50:26 AM

Page 1

Item ID: D3537-1

Accept

Revision ID:

Item Name: Wearpad

Start Date: 1/19/10 Start Qty: 40.00

Required Date: 1/25/10 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: *RS*

Date: *10-1-19* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3537	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

304 .063

1-Cut as per Dwg D3537...Dwg Rev: *C* Prog Rev: *C* 2-Deburr if necessary

IB 10-1-25

(72)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 10-1-25

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

278 10/1/26

counter
(+72)

φ

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Item ID: D3537-1

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Revision ID:

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Item Name: Wearpad

Start Date: 1/19/10 Start Qty: 40.00

Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 40.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

8 12/10/28

72

140

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Qty Description Batch 1A/R 2059B Hardcoat
M 113521 1-Weld as per Dwg D3537 using Jig DT 8210. 2-Remove any weld that penetrated through Wearpad if necessary

EL

72
10-2-9

150

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

=> 5.10.10.09

center
72

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

=> 5/02/07

counted
(72)

QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M112588

0.00

=> M 10/02/10

(72) ✓

Powdercoat

Memo

Powder Coating

START TIME: 3:15pm FINISH TIME: 3:45pm OVEN TEMPERATURE: 320°F

180

QC3- Inspect Part Finish

0.00

Bl 10-02-11

(72)

QC

Memo

0.00

Quality Control

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: FR-13

0.00

JA 10/02/11



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11 JA

MF 10-2-11

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NOTE: Date & initial all entries

Picklist Print

January 19, 2010 9:50:30 AM

Page 1

Work Order ID: 55465



Parent Item: D3537-1



Parent Item Name: Wearpad

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:A New Issue 07-02-14 JLM

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	260.9779	4.4632	8.1		



304/316 Sheet .063



4310-1-25

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	260.9778737	
106860	8.0295	
111924	25.1689737	
112442	29.8899	
113295	197.8895	

72

13295

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DART AEROSPACE LTD		Work Order:	55465
Description: Wearpad		Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4.256	✓			
3.500	+/-0.010	3.500	✓			
1.965	+/-0.010	1.968	✓			
2.795	+/-0.010	2.796	✓			
3.625	+/-0.010	3.625	✓			
0.220 x 0.380	+/-0.010	0.225 x 0.384	✓			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-1-25	Date: 10/6/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	

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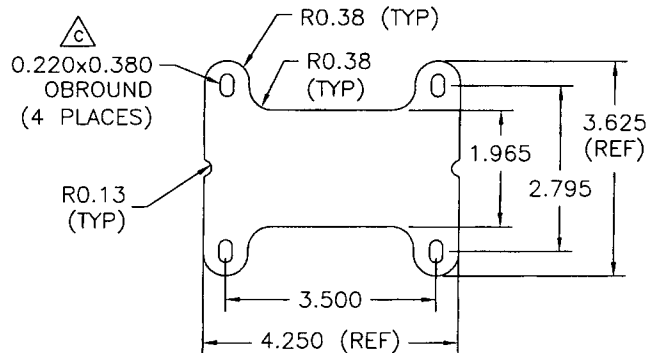
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

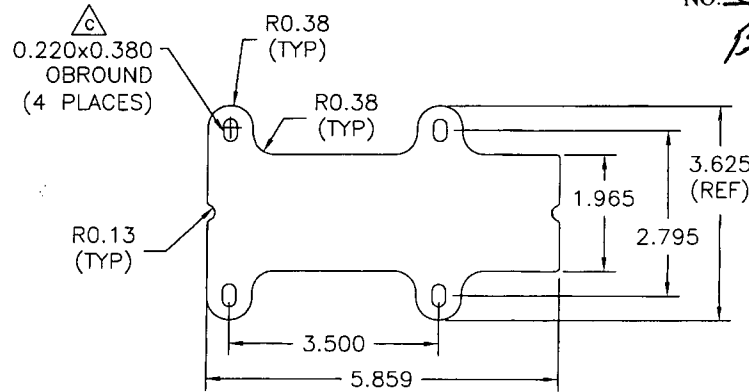
NO. 55465

BJ10-1-19

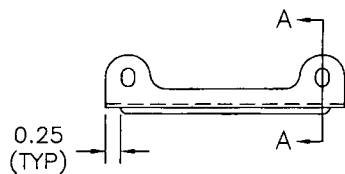
D3537-1F FLAT PATTERN



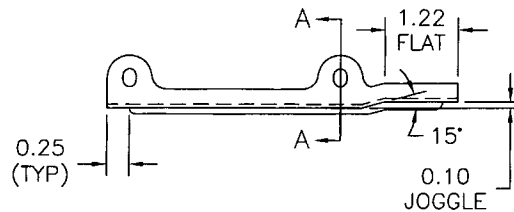
D3537-3F FLAT PATTERN



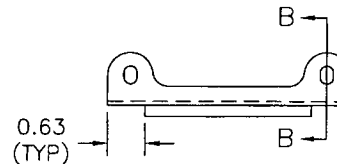
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



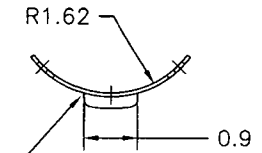
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

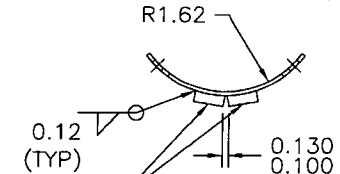


SECTION A-A



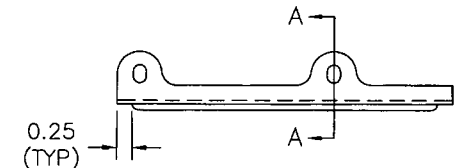
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET 1 OF 1		SCALE 1:2

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

RELEASED
07.05.08
per ECN
962

W/O:		WORK ORDER CHANGES					
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